

Date: Thursday, 7/13/2006 3:28:22 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD MOUNTING LUG
Job Number	: 27886		
Estimate Number	: 10453		
P.O. Number	: <i>N/A</i>	Part Number	: D26162
This Issue	: 7/13/2006	Drawing Number	: D2616 REV D3
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: D3
Previous Run	: 24943	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 8/15/2006
Checked & Approved By	: <i>[Signature]</i> 06.07.13	Qty:	50 Um: Each
Comment	: Est Rev. 00.06.22 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
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Comment: Qty.: 0.1749 f(s)/Unit Total : 8.7465 f(s)

Material: 6061-T6 QQ-A-200/8 2" X 1" Bar

Batch *M18745 X10* *M161421 X40*

ml 06/08/05 50

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 2.000" long +0.030" -0.000"

ml 06/08/05 50

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2616-2 & DWG D2616

2-Tumble & Deburr

ml 06/08/05 50

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/08/05 50

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 06/08/08 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-08-09

(50)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Mask large hole

a.m 06-08-10

(50)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/08/11

(50)

9.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2611

Bearing

(2) B 27525

B 27901

(48)

SB 06/08/31

50

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Coat bearing in light oil

2-Press Bearing in D2616-2

3-Stack as per Dwg D2616 using DT8019

4- Touch up paint if required

SB 06/09/07

(50)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/07

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 06/09/14

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 50193

Rec'd 8/11

50

13.0

DC

DOCUMENT CONTROL



(50)

Comment: DOCUMENT CONTROL

Inspection Level 21

D 26/09/11

Job Completion



U Dec 9.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

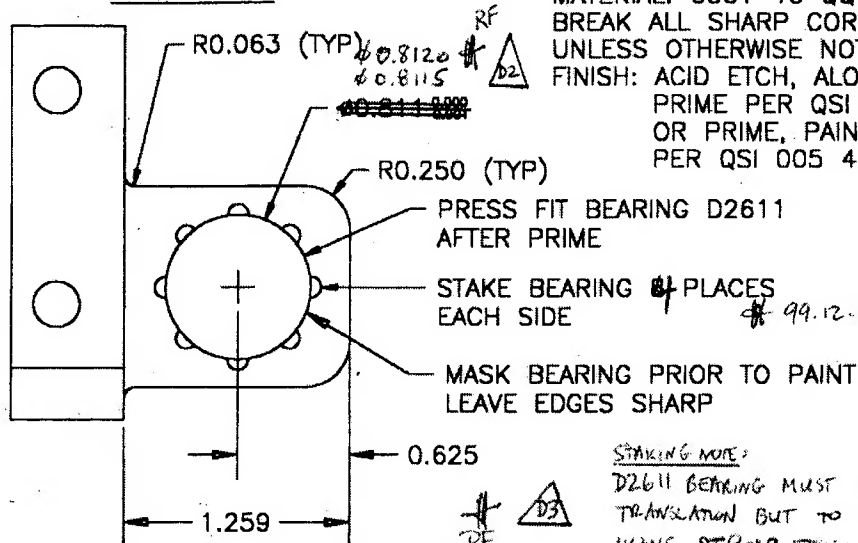
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>BW</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>BW</i>	DRAWING NO. D2616	REV. D SHEET 1 OF 1
DATE 97.07.31		TITLE FWD MOUNT LUG	SCALE 1:1
D1	99.12.16	STAKE 4 PLS INSTEAD OF 2 PLS/SIDE	A
D2	00.11.21	CHG. HOLE TOL. PER NCR 449.	B
D3	02.09.70	ADD STAKING NOTE PER CAR 107	C
D	97.07.31	D2611 WAS CBA-6-B2	

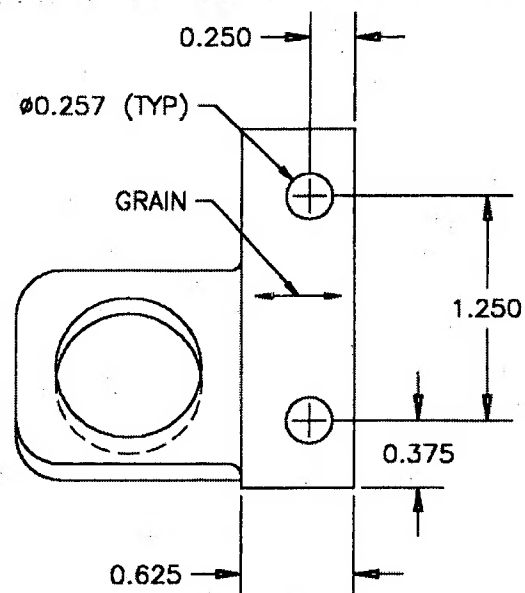
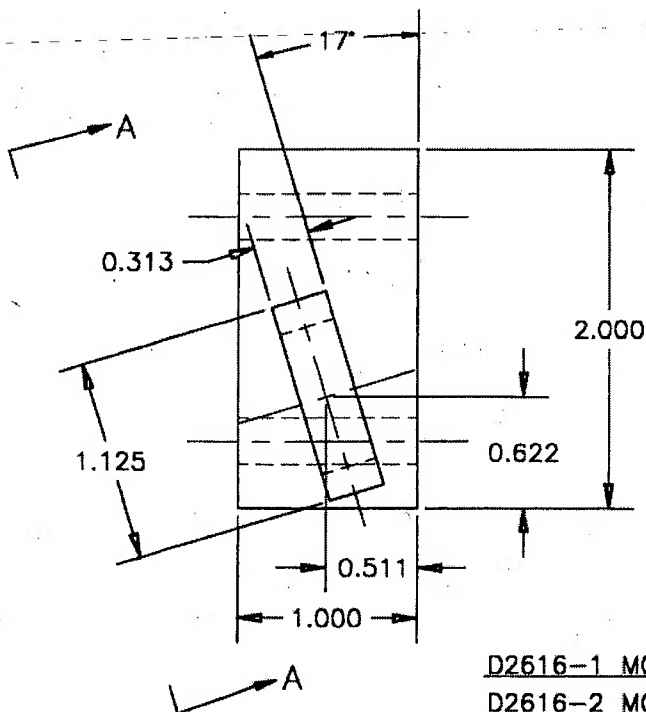
VIEW A-A



MATERIAL: 6061-T6 QQ-A-200/8
BREAK ALL SHARP CORNERS 0.010 TO 0.020
UNLESS OTHERWISE NOTED
FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
PRIME PER QSI 005 4.2
OR PRIME, PAINT PER CUSTOMER SPEC
PER QSI 005 4.2

RELEASED
970731 BW

STAKING NOTE:
D2611 BEARING MUST BE STAKED TO PREVENT
TRANSLATION BUT TO STILL ALLOW ROTATION
USING DT8019. TOUCH UP PAINT AFTER STAKING.



D2616-1 MOUNTING LUG SHOWN
D2616-2 MOUNTING LUG OPPOSITE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY